Work Orde				<u>\*77(</u>	191*1							Page 1
Revision ID:	D3204-7 Bushing			Accept	*N900	040	100	)*	Setup	Start Stop	1.7	S1* S2*
Start Date: Required Date: Reference:	25/11/2011 09/12/2011	Start Qty: 8.00 Req'd Qty: 8.00	*8* *8*		Cust Item 1 Customer:							
Approvals:	Process Pla	n: <u>M L J</u>	Date: \\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\			ate:			Run	Start Stop	1/1	R1* R2*
Sequence ID/ Work Center II	)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Reje Qty		Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr										*
D3204	Rev	A1										
100		-		0.00								00 ,
*100*		Hardinge CNC LATHE	SMALL					8	_ 0	)		Sf 11/12/20
Hardinge Hardinge CNC Lathe	e Small	<b>Memo</b> 1-Turn D32	04-7 bushing as per Folio FA	0.00 a355 and Dwg D32042-	-Deburr							
110		QC2- Inspect parts off n	nachine FAI/FAIB	0.00				23				11
*110* QC Quality Control		Мето		0.00				8	0	* Marie -		SI nlizle
120		QC8- Inspect parts - sec	ond check	0.00					ſ	1		
*120* QC Quality Control		Memo		0.00	je (1.12.	23		8	<i>d</i>	<del></del>	<u></u>	

Dart Aerospace Li	d
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W/O:		WORK ORDER CHANGES									
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng /	Approval QC Inspector		
								Prod Mgr			
									:		
				:							
Part No	:	PAR #:	Fault Categ	jory:	NCR: Yes	No DQ	A:	_ Date: _			
	Res	solution:	Disposition	ı:	QA: N/C CI	osed:		Date: _			
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NCF	₹)					
DATE	CTED	Description of NC Corrective Action			ction B	Verific	cation	Approval	Approval		
DATE	STEP	Section A	Initial Action Description Chief Eng Chief Eng		Sign 8 Date	Sign & Section		Chief Eng	QC Inspector		
								:			
	•										
									·		

Work Order ID 77091  November-25-11 10:54:03 AM				*77(	Page 2				
Item ID: Revision ID: Item Name: Start Date:	D3204-7 Bushing 25/11/2011	Start Qty: 8.00	*8*	Accept	*N900040	)1NN³	k Setup	Start Stop	*NS1* *NS2*
Required Date Reference:	e: 09/12/2011	Req'd Qty: 8.00	*8*		Customer:				
Approvals:		n:		0	Date:		Run	Start Stop	*NR1*
	QC:		Date:	SPC (Y/N):	Date:				*NR2*
Sequence ID/ Work Center I	ID	Operation Description Identify as per dwg & St	ock Location: GA.	Set Up/ Run Hours 0.00	Tool ID Tool #		Accept Re		Reject Insp. Number Stamp
*130* Packaging Packaging		Memo		0.00		Ex	)SP	/(= /	12-23.
140 *1 <b>4</b> 0*		QC21- Final Inspection -	Work Order Release	0.00				[.]	112/28/
QC Quality Control		Memo		0.00				<u></u>	
								K	11223

Dart Ae	rospace	e Ltd						•
W/O:			W	ORK ORDER CHANGE	ES			
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:						
	R	esolution:					Date: _	
NCR:		V	WORK ORE	DER NON-CONFORMA	NCE (NCR	)		
DATE	OTED	Description of NC		Corrective Action Section		Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector

### **Picklist Print**

November-25-11 10:54:07 AM

Work Order ID: 77091

D3204-7

Parent Item Name: Bushing

\*77091\* \*D3204-7\*

**Start Date: 25/11/2011** 

**Required Date:** 09/12/2011

Page 1

Start Qty: 8.00

Required Qty: 8.00

**Comments:** 

Parent Item:

IPP: B04.06.09Change Step 6; remove Steps 7 & 8KJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.500		Purchased	No			100	f	473.8660	0.0358	0.301474			
*M303R0 5	500*								**	0.303		·	SI 11/12/2

303 Round Bar 0.500"

Location	Loc Qty	Loc Code	
MAT028	473.866		
117143	11.34		
118271	11.9		
118509	12.69		
119009	269.936		
119616	168		0.303'

W/O:			WC	RK ORDER CHANG	FS				
DATE	STEP	PR	OCEDURE CHAI		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						·			
						·			
Part No	•	PAR #:	Fault Cate	jory:	_ NCR: Yes	No DQ	A:	Date:	<u> </u>
	Re	solution:	Disposition	:	_ QA: N/C CI	osed:		Date: _	-
NCR:			WORK ORDE	R NON-CONFORMA	ANCE (NCF	R)			
DATE	STEP	Description of NC			Section B Verifi			Approval	Approval
DATE	SIEP	Section A	Initial Action Description Chief Eng Chief Eng		Sign 8 Date	Sign &   Section C		Chief Eng	QC Inspector

DART AEROSPACE LTD	Work Order:	77091
Description: Bushing	Part Number:	D3204-7
Inspection Dwg: D3204 Rev: A1		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.063	+/-0.010		-			
0.303	+/-0.010	0.0645				
0.030 x 30°	+/-0.010	0.3045 0.030 x 30°				
Ø0.500		6.030 X 30				
Ø0.376	+0.001/-0.000	40.500				
Ø0.257	+0.001/-0.000	60.500 60.3764 60.2575				
20.207	10.0007-0.000	00.0373				1,11,11,11,11,11,11,11,11,11,11,11,11,1
					·· .	
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Measured by:	St	Audited by:	RQ	Prototype Approval:	N/A
Date:	11/12/22	Date:	11.12.23	Date:	N/A

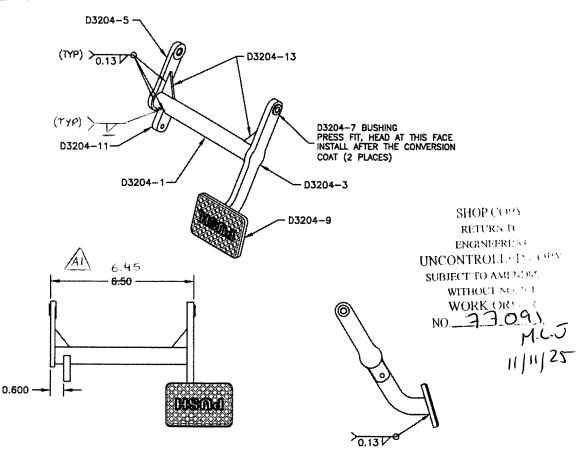
Rev	Date	Change	Revised by	Approved
Α	05.02.17	New Issue	KJ/JLM ,	1
В	06.03.21	Dwg Rev update	KJ/JLM	Gul

W/O:	· ·		WC	ORK ORDER CHANG	SES			<u>-</u>			
DATE	STEP	PROCEDURE CHANGE				,	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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							-				
		, .									
Part No:			Fault Cate	gory:	NCR: Yes No DQA: Date:						
	Res	solution:	ution: Disposition:				QA: N/C Closed:				
NCR:			WORK ORDI	ER NON-CONFORM	ANCE (N	CR)					
DATE	STED	TEP Description of NC Section A	Corrective Action Section B			Sign &		tion	Approval	Approval	
DAIL	J.L.		Section A Initial Action De Chief Eng Chief					C	Chief Eng	QC Inspector	
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		*									
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CHEC	KED, A	APPROVED	DRAWING NO.		REV. A
	#		D3204	SHEET	1 OF 3
DATE	<b>V</b>		TITLE	***************************************	SCALE
04.0	01.27		RELEASE PEDAL ASSEMBLY		NTS
Α	i	04.01.27	NEW ISSUE		
A۱	4	05.07.15	6.45 WAS 6.50		



### D3204-041 RELEASE PEDAL ASSEMBLY

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
  6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020 ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
  7) WELD ASSEMBLY PER QSI 004

- CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

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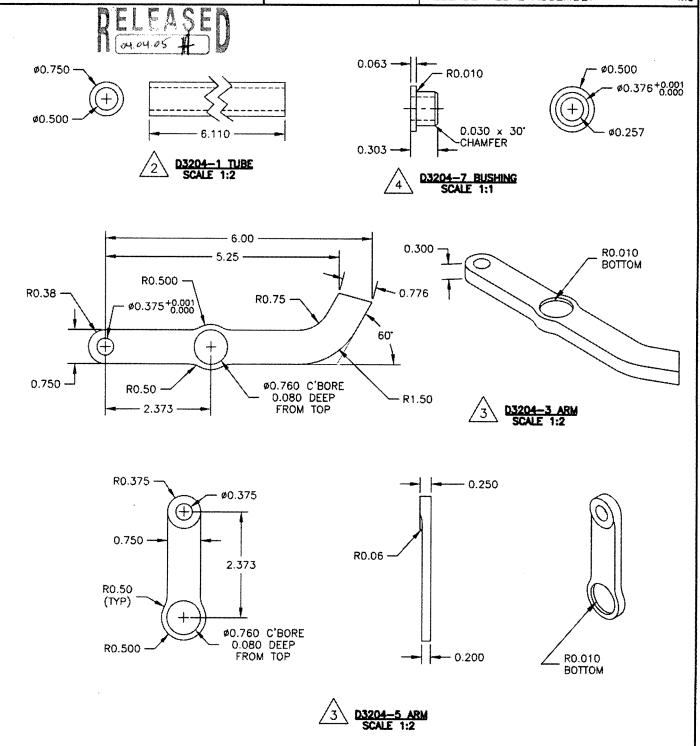
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W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE					Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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		·				,					
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DATE	OTED	Description of NC	Corrective Action Sect				Verification		Approvai	Approval	
DATE	SIEP	STEP Description of NC Section A	Initial Chief Eng	Action Description Chief Eng		gn & ate	Section C		Chief Eng	QC Inspector	
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CHECKED	APPROVED	DRAWING NO.		REV.	A
#	#	D3204	SHEET	2 OF	3
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04.01.27		RELEASE PEDAL ASSEMBLY		N	ITS



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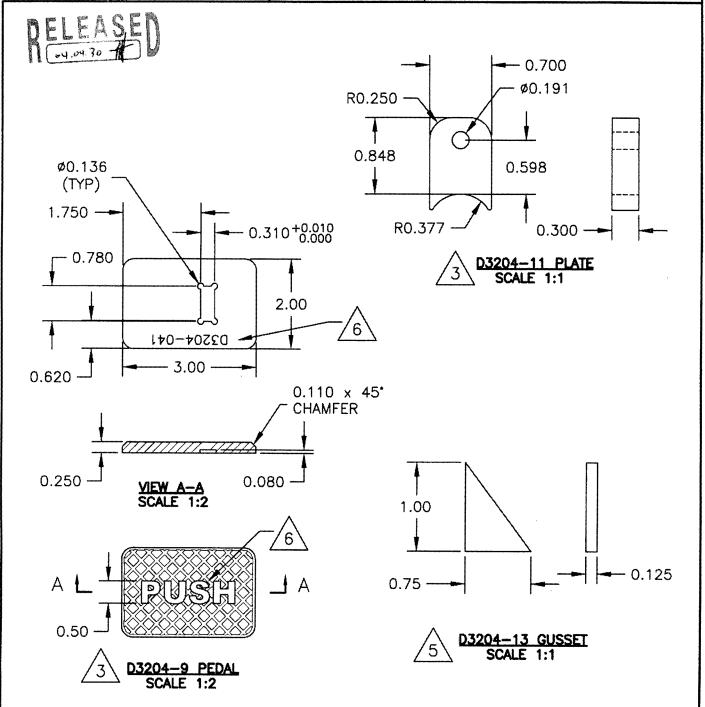
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W/O:		WORK ORDER CHANGES										
DATE	STEP	PROCEDURE CHANGE					Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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NCR:			WORK ORE	ER NON-CONFORM	ANCE (	NCR)	)					
DATE	CTED	Description of NC		tion B			ation	Approval	Approval			
DATE	STEP	Section A	initial Chief Eng	Action Description Chief Eng		Sign & Date	Section		Chief Eng	QC Inspector		
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04.01.27		RELEASE PEDAL ASSEMBLY		N	TS



W/O:			V	VORK ORDER CHAN	IGES							
DATE	STEP	PROCEDURE CHANGE					Date C	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No:		PAR #:	Fault Ca	tegory:	NCR: Yes No DQA: Date:							
	Res	olution:	Disposition:				sed:		Date:			
NCR:		,	WORK OR	DER NON-CONFORM	MANCE	(NCR	)					
DATE	STEP	Description of NC Section A	Corrective Action Section B			Cian ?	Verificati		Approval	Approval		
DAIL	SIEF		Initial Chief Eng	Action Description Chief Eng	n	Sign & Date	Section C		Chief Eng	QC Inspector		
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